



Dart Aerospace Ltd.
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004374

D4880-041
Job Sheet 180539



Ship Alone

Part No: D4880-041

Job Qty: 3 ea

Part Name: 206A/B FWD Leg Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/9/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		8/7/18	0.00	0.00	Start Up Small Fab-4	8-8.5	AUG 29 2018
110	Small Fab	3 pcs		8/7/18	0.00	1.65	Small Fab-8	8-8.5	38
120	QC	3 pcs		8/7/18	0.00	0.00	QC5		38
130	Small Fab	3 pcs		8/7/18	0.00	1.65	Small Fab-8		38
140	QC	3 pcs		8/7/18	0.00	0.00	QC5		38
180	Packaging	3 pcs		8/7/18	0.00	0.00	Packaging3-2	5/1/15	38
190	QC21-SA	3 Ea		8/7/18	0.00	0.00	QC21	8-8.5	38

Part Op 110 - ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 AND D4884-1. DRILL OUT EACH HOLES
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9971 AS PER DWG.
130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9971 A/R HYSOL BATCH: 38845 2- LASER ENGRAVE PART# AND SERIAL # AS PER DWG
5080785

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4880-1	Strut	3 Ea (1 ea)	90-Start up Operation	5010265X1 5096620X2
D4883-7	End Fitting	3 Ea (1 ea)	90-Start up Operation	5003367
D4884-1	End Fitting Eye	3 Ea (1 ea)	90-Start up Operation	5096749
HL32PB5-12	Hi-Lok Pin	12 Ea (4 ea)	90-Start up Operation	5008248X11 5043979X1
HL86-5	Hi-Lok Collar	12 pcs (4 ea)	90-Start up Operation	FM129022 X12

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4880-1	3	3	0
	D4883-7	3	10	0
	D4884-1	3	0	0
	HL32PB5-12	12	32	0
	HL86-5	12	95	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				FAULT CATEGORY Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			

DART AEROSPACE
 Container No: S106599
 Part: D4880 - 041
 Job No: 180539
 Serial No/Batch: S106599
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 08/29/18

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Supervisor
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